Qty:

12 Um:

Each

: WEARSHOE

: D353541

: 05/10/2008

: N/A

: B

: D3535 REV B

Date:

Tuesday, 23/09/2008 1:00:22 PM

User: Julie Lecocq

#### **Process Sheet**

**Drawing Name** 

Part Number

Material

**Due Date** 

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

: 42256

Job Number **Estimate Number** 

: 12728

P.O. Number

This Issue : 23/09/2008

: NC Prsht Rev.

First Issue

: // : 31993 **Previous Run** 

Written By

**Checked & Approved By** 

Comment

: Est Rev:A

S.O. No. :

Type

Est Rev:B As per Rev B 07-08-31 JLM

New Issue 07-02-15 JLM

: SMALL /MED FAB

Verified By:EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description: 304/316 .040 Sheet

1.0

M304S20GA

Comment: Qty.:

0.5355 sf(s)/Unit Total:

6.4260 sf(s)

304/316 .040 Sheet

(M304S20GA)

2.0

WATER JET

FLOW WATER JET



**Comment: FLOW WATER JET** 

1-Cut as per Dwg D3535

Dwg Rev:\_ Prog Rev:\_

H8-11-5

2-Deburr if necessary

3.0 QC2



188-11-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

4.0

SECOND CHECK

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

SB 08/10/05

13

Dart Aerospace I	Ltd
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W/O:			) F	W	ORK ORDER CHAN	IGES				
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	sday, 23/09/2008 1:00:22 PM e Lecocq	Dragge Short	
1		Process Sheet	
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: WEARSHO	DE ·
Job Number:	42256	Part Number: D353541	
Job Number:		,	
Seq. #:	Machine Or Operation:	Description :	
	Form Joggle on brake using Jig DT81		108/11/06 (13)
6.0	QC5	INSPECT WORK TO CURRENT STEP	
	ent: INSPECT WORK TO CURRENT STEE		OS 11 00 (+B)
7.0	POWDER COATING	10 6442	13x
Commo	ent: POWDER COATING		
	Powder Coat Grey Sandtex (Ref. 4.3.5	5.6) as per QSI 005 4.3	
	START TIME: 5	0 /	a de calular
	FINISH TIME: CYC		1/1/08/11/06
8.0	QC3	INSPECT POWDER COAT/CHEMICAL COM	NVERSION (3)
	ent: INSPECT POWDER COAT/CHEMICA		FZ 98/11/06
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comme	ent: PACKAGING RESOURCE #1		$\alpha$
10.0	Identify and Stock Location: P-/8	FINAL INSPECTION/W/O RELEASE	FL 08/11/06 (3)
		FIIVAL INOPEG HONVWO RELEASE	08/11/07 4
Comme	ent: FINAL INSPECTION/W/O RELEASE	Name day	. 0
Job Completion			mf 08-11-06
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# **Dart Aerospace Ltd**

Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:								ES	R CHANG	RK ORDER	WC		ſ		<del> </del>		-	W/O:
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Description: Wearshoe	Part Number:	D3535-41
Description. Wouldnot	T dit Number:	20000-41
Inspection Dwg: D3535 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.001	X			
Ø0.188	+0.005/-0.001	,190	*			.,
5.00	+/-0.030	Sioor	8			٠.
1.885	+/-0.010	1,887	×			
29.079	+/-0.010	29.079	*			
25.079	+/-0.010	25,079	×			
18.497	+/-0.010	18.497	6			
14.997	+/-0.010	14.997	8			
12.472	+/-0.010	17,477	~			
8.972	+/-0.010	8,970	*			
6.932	+/-0.010	6.930	×			
3.432	+/-0.010	3,430	\%			
2.000	+/-0.010	3.000	36			
0.300	+/-0.010	.304	Ø			
0.300	+/-0.010	.303	<b>X</b>			
0.038	+/-0.010	,039	8			'
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Measured by:	B	Audited by:	7	ł	7	Prototype Approval:	N/A
Date:	8-11-5	Date:	08/1	405		Date:	Ň/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM 🕠	B

Dart Ae	rospace	e Ltd	- [								
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### **Dart Aerospace Ltd** W/O: WORK ORDER CHANGES Approval **Approval** DATE STEP PROCEDURE CHANGE By Date Qtv Chief Eng / QC Inspector Prod Mar Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE STEP Sign & Initial **Action Description** Section A QC Inspector Section C Chief Ena Chief Eng Chief Eng Date

ps. 40.70

DML MASK





D3535-31F FLAT PATTERN

22.500

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D3535-31 BEND DETAIL

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PURPOSE

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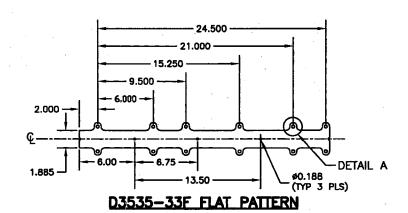
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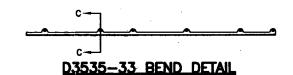
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DETAIL A #0.188 (TYP 3 PLS)

AISI 304/316 SS SHEET PER AMS 55 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA) 1) MATERIAL:

- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION





CB	<b>*</b>	DART AEROSPACE USA, INC.	A, INC.
CHECKED //	APPROVED i//	DRAWING NO.	REV. B
	4	D3535	SHEET 4 OF 7
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Dart	Aerospace Ltd
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AEROSPACE PORT HADLOCK,

USA,

NC.

D3535 DRAWING NO.

SHEET

5 OF 7 REV.

SCALE 1:10

07.04.17

# 35F FLAT PATTERN

#0.188 (TYP 2 PLS)

DETAIL A

23.250 19.750



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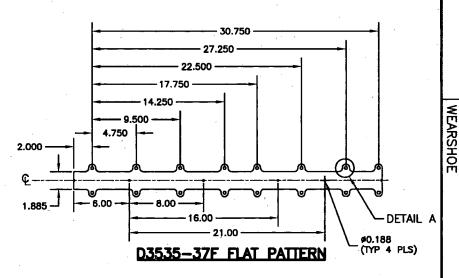
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PURPOSE

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COPIED

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

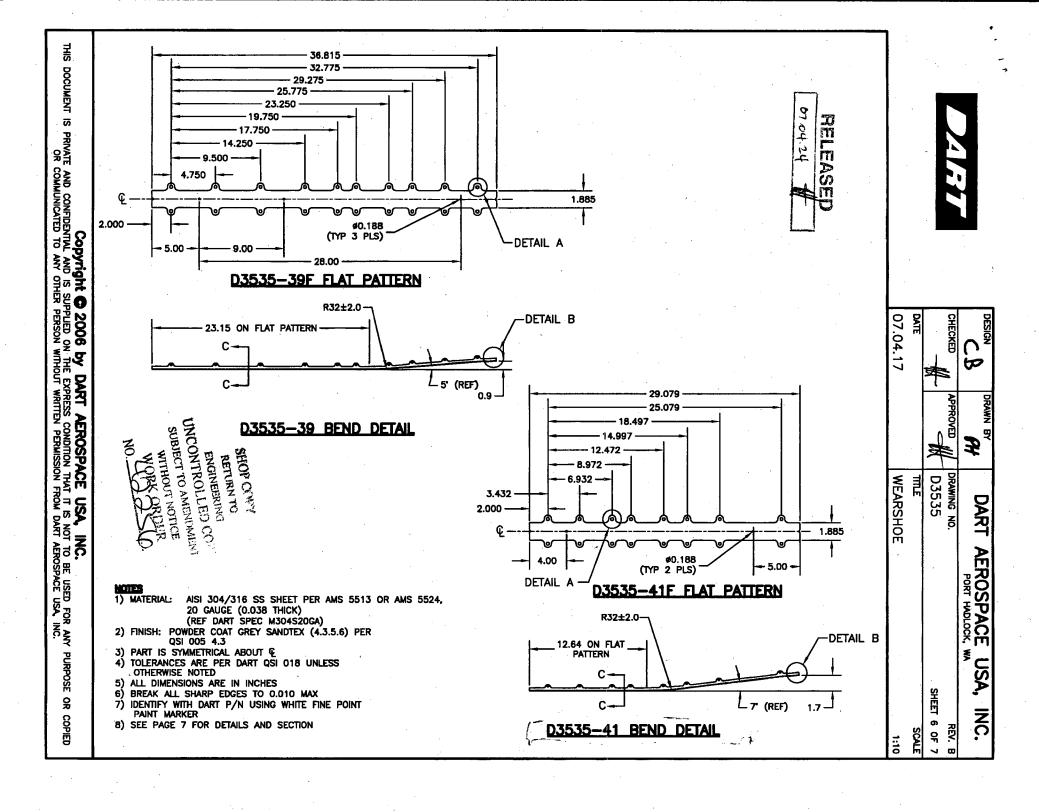




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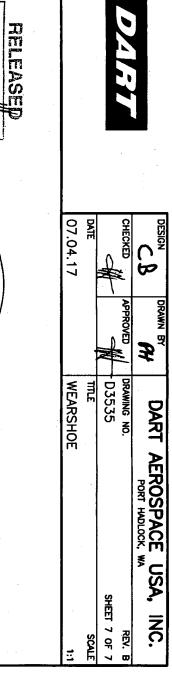
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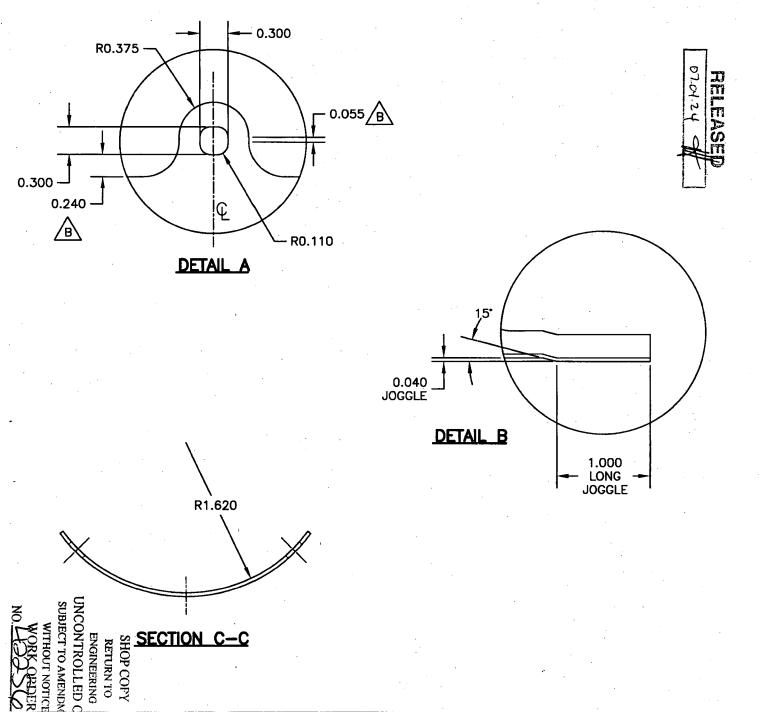
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